

Work Order ID 111932

January-27-14 12:56:02 PM

ASA
111932

Page 1

Item ID: D4095-043

Revision ID:

Item Name: Wearplate Assembly

Start Date: 1/27/14

Start Qty: 12.00

12

Required Date: 2/10/14

Req'd Qty: 12.00

12

Reference:

Approvals:

Process Plan: MJS

Date: 14-01-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4095

B

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-3)

Dwg Rev: 3

Prog Rev: 3

2-Deburr if necessary

12 0 Ae
14.02.05

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12 0 Ae
14.02.05

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

12 14.02.05
DAS
9
9-89

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Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/27/14 **Start Qty:** 12.00 ***12***

Cust Item ID:

Required Date: 2/10/14 **Req'd Qty:** 12.00 ***12***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

- 1- bend section C-C first
- 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155
- 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157

DAS
30
9-89

12

14102106

140

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D4095

DAS
27
9-89
M12/6

12

150

150

Weld per dwg A/R Hardcoat S.S. Batch: *126843* 0.00

0.00

Large Fab

Memo

0.00

Large Fab

12 JBL/A 14-2-14

January-27-14 12:56:02 PM

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/27/14 **Start Qty:** 12.00 ***12***

Cust Item ID:

Required Date: 2/10/14 **Req'd Qty:** 12.00 ***12***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC10- Inspect visual per OSI004- ground welds	0.00	
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160

OC

Memo

0.00

Quality Control

170	QC5- Inspect part completeness to step on W/O	0.00
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170

OC

Memo

0.00

Quality Control

180 0.00

180

HandFinish

Memo

0.00

Hand Finishing

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER
DWG
A/R ROCKGUARD BATCH: 127716

Work Order ID 111932

January-27-14 12:56:02 PM

111932

Page 4

Item ID: D4095-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 1/27/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 2/10/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12x	d	ll	14/02/19
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-002</u> Memo	0.00 0.00				12x	d	ll	14/02/19
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						ll	14-02-19

Handwritten signature and date: 14-02-19

Picklist Print

Page 1

January-27-14 12:56:06 PM

Work Order ID: 111932

111932

Parent Item: D4095-043

D4095-043

Parent Item Name: Wearplate Assembly

Start Date: 1/27/14

Required Date: 2/10/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

371.4170

2.275

29

M304S16GA

Ac 14.02.05

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

371.417

M126915

2.487

M127821

168.93

M128054

200

128054 → 29

DART AEROSPACE LTD		Work Order:	111932
Description: Wearplate		Part Number:	D4095-3
Inspection Dwg: D4095	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

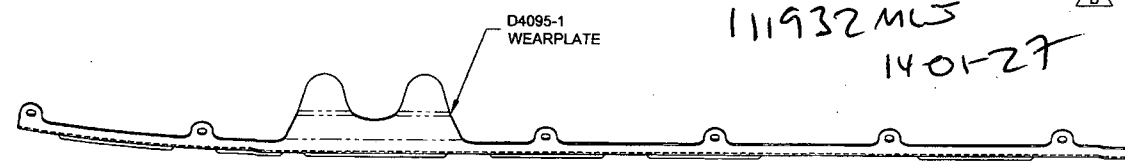
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.192	-		✓	JKm-05
0.300	+/-0.010	.301	-		✓	
0.300	+/-0.010	.304	-		✓	
2.432	+/-0.010	2.432	-		✓	
3.227	+/-0.010	3.227	-		✓	
4.06	+/-0.030	4.06	-		T	JKm-06
2.50	+/-0.030	4.98	-		T	
4.98	+/-0.030	8.43	-		T	
8.43	+/-0.030	11.50	-		T	
11.50	+/-0.030	11.50	-		T	
21.750	+/-0.010	21.750	-		T	
3.500	+/-0.010	3.500	-		T	
12.22	+/-0.030	12.22	-		T	
6.000	+/-0.010	6.000	-		T	
12.100	+/-0.010	12.100	-		T	
21.00	+/-0.030	21.00	-		T	
30.000	+/-0.010	30.000	-		T	
36.000	+/-0.010	36.000	-		T	
38.88	+/-0.030	38.88	-		T	
0.063	+/-0.010	.059	-		✓	

DAS

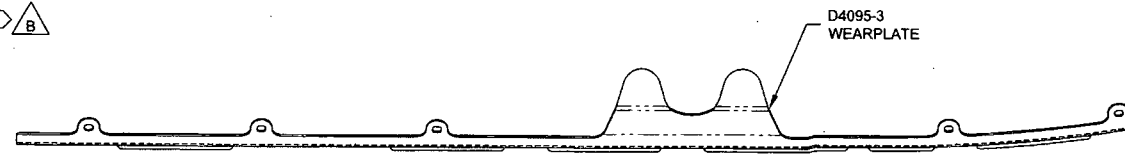
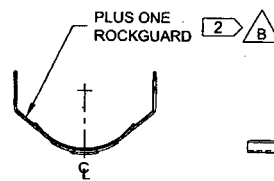
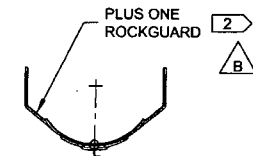
Measured by: Ae	Audited by: 9 9-89	Preliminary Approval:
Date: 14.02.05	Date: 14.02.05	Date:

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-043	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	

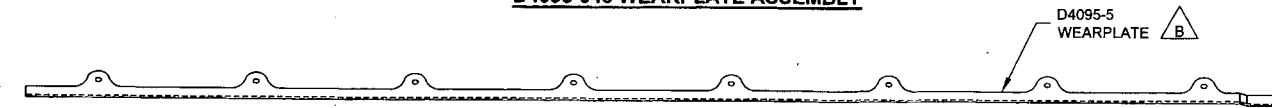
ITEM	QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



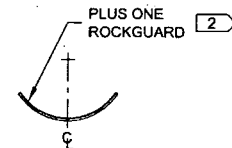
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY



D4095-041/-043/-045/-047/-049/-051 NOTES:

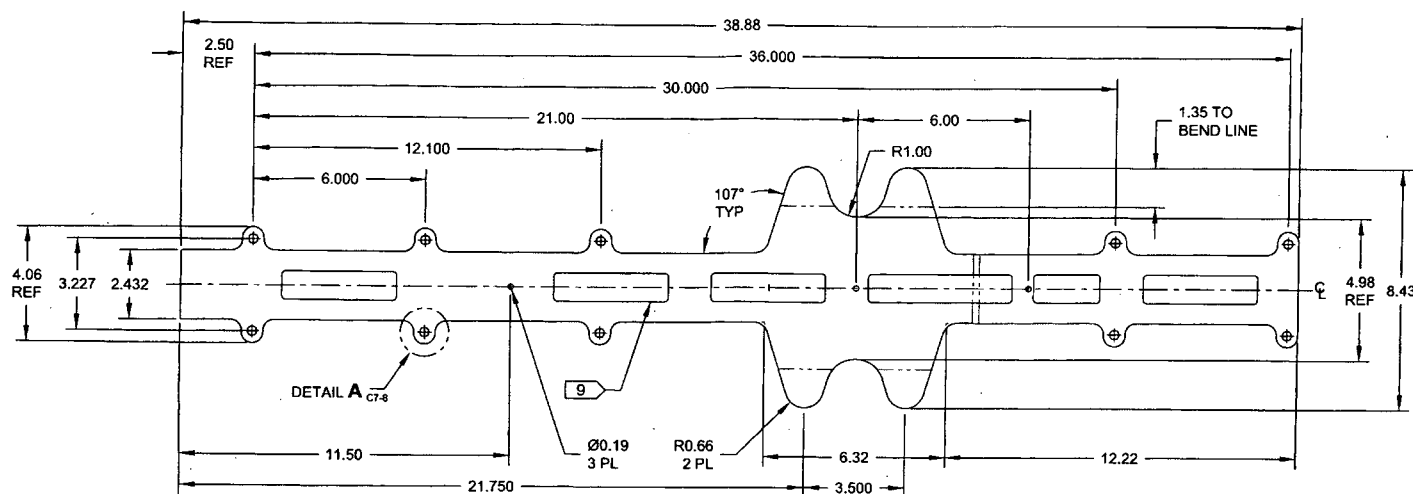
- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4095-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.18		

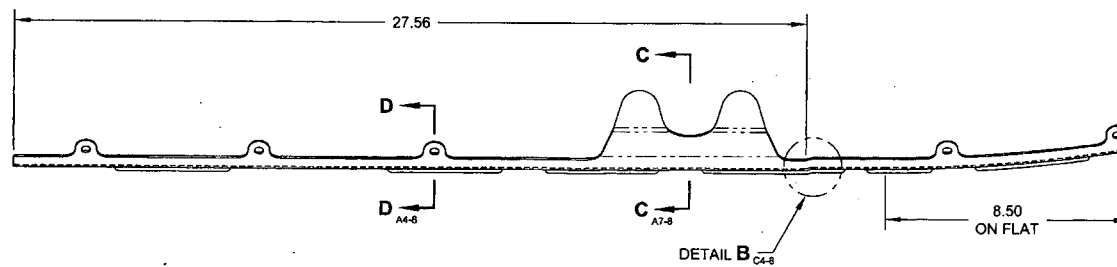
DART AEROSPACE USA, INC
KENT, WA

DRAWING NO. D4095
TITLE WEARPLATE
REV. B
SHEET 1 OF 8
SCALE
NTS

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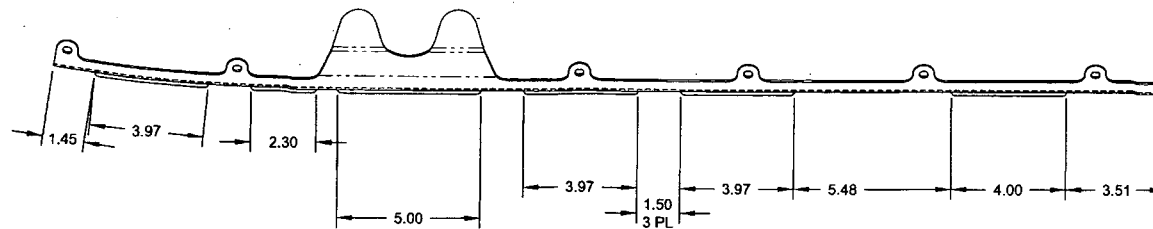
D4095-3F FLAT PATTERN 1



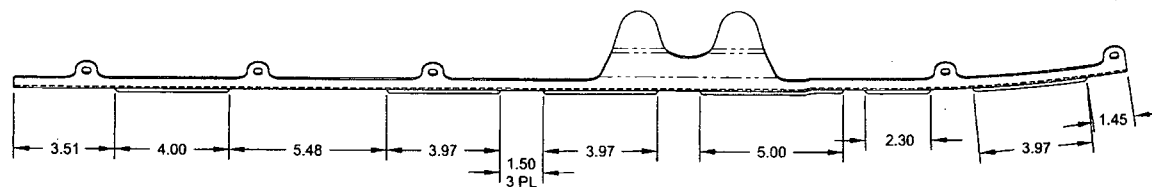
D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

RELEASE
2011-10-31

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 4 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE	NTS
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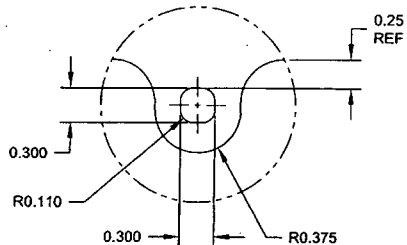
D4095-1 WELDING DETAIL 



D4095-3 WELDING DETAIL 

RELEASED
2011-10-31
M

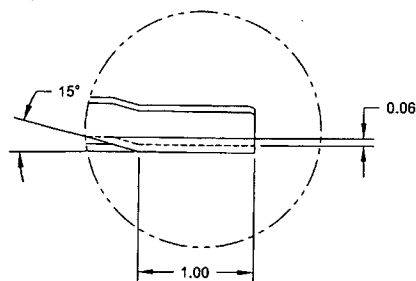
DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>AP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AP</i>	D4095	SHEET 5 OF 8
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	WEARPLATE	NTS
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DETAIL A: TAB DETAIL

SCALE 4X

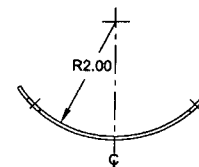
C3-3
C6-4
D3-6
D2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

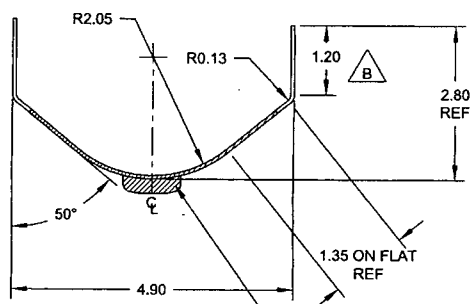
B2-3
B6-3
B3-4
B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

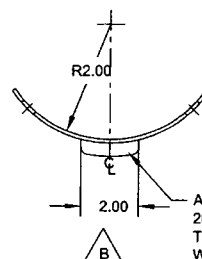


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

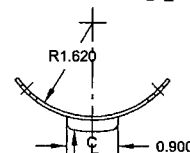


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

RELEASED
2011-10-31
MP

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 8 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
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